



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.9713
Job Sheet 181424



Part No: 646.9713

Job Qty: 40 ea

Part Name: Body



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E SHEETS 1-4, 7 IPP Rev.A New issue JFS 16/03/08 Verify by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea	9/10/18	9/10/18	0.00	0.00	Start Up Machining-1		Kt 2018-10-06
100	Bandsaw	40 pcs	9/10/18	9/10/18	0.00	6.84	Bandsaw1		Kt 2018-10-06
110	CNC Vertical Machining	40 pcs	9/10/18	9/10/18	0.60	58.82	HAAS1-1		Kt 2018-10-06
120	QC	40 pcs	9/10/18	9/10/18	0.00	0.00	QC2 Machining-1		Kt 2018-10-06
130	QC	40 pcs	9/10/18	9/10/18	0.00	0.00	QC8 Machining-1		Kt 2018-10-06
140	Outsource	40 pcs	9/10/18	9/10/18			ATG001-VC	PO41337	OCT 15 2018
150	Packaging	40 pcs	9/10/18	9/10/18	0.00	0.00	Packaging2		NOV 15 2018
155	QC	40 pcs	9/10/18	9/10/18	0.00	0.00	QC5		NOV 16 2018
180	Packaging	40 pcs	9/10/18	9/10/18	0.00	0.00	Packaging3-1	C4013	NOV 19 2018
190	QC21-SA	40 Ea	9/10/18	9/10/18	0.00	0.00	QC21		NOV 19 2018

Part Op 100 - Cut Blank at 7.425"

Descriptions: 110 - 1-Machine per folio FB464

140 - Issue P/O to ATG : _____ Anodize, Color Black, Prime as per Dwg 646.9700

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

DAS 21 NOV 19 2018
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.000X5.000	7075-T6 Sheet 1" Thick Plate X 5" Wide	24.8000 ft (.62 ea)	90-Start up Operation	

5104641 = 13x

5084996 = 18x

5104641 = 9x

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S1.000X5.000	25	29	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Body	0.487Inches ± 0.005	0.492 0.482		
2	Body	4.784Inches ± 0.002	4.786 4.782		
3	Body	3.603Inches ± 0.002	3.605 3.601		
4	Body	2.422Inches ± 0.002	2.424		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

			2.420
5	Body	1.400Inches $\pm$ 0.002	1.402 1.398
6	Body	0.375Inches $\pm$ 0.002	0.377 0.373
7	Body	0.409Inches $\pm$ 0.002	0.411 0.407
8	Body	0.350Inches $\begin{matrix} + 0.005 \\ - 0.000 \end{matrix}$	0.355 0.350
9	Body	0.875Inches $\pm$ 0.005	0.880 0.870
10	Body	1.067Inches $\pm$ 0.002	1.069 1.065
11	Body	2.608Inches $\pm$ 0.002	2.610 2.606
12	Body	2.750Inches $\pm$ 0.002	2.752 2.748
13	Body	2.892Inches $\pm$ 0.002	2.894 2.890
14	Body	3.348Inches $\pm$ 0.002	3.350 3.346
15	Body	3.597Inches $\pm$ 0.002	3.599 3.595
16	Body	3.847Inches $\pm$ 0.002	3.849 3.845
17	Body	0.544Inches $\pm$ 0.002	0.546 0.542
18	Body	2.195Inches $\pm$ 0.002	2.197 2.193
19	Body	3.395Inches $\pm$ 0.002	3.397 3.393
20	Body	3.495Inches $\pm$ 0.002	3.497 3.493
21	Body	4.595Inches $\pm$ 0.002	4.597 4.593
22	Body	4.687Inches $\pm$ 0.002	4.689 4.685
23	Body	4.734Inches $\pm$ 0.002	4.736 4.732
24	Body	0.177Inches $\begin{matrix} + 0.005 \\ - 0.001 \end{matrix}$	0.182 0.176
25	Body	0.201Inches $\begin{matrix} + 0.005 \\ - 0.001 \end{matrix}$	0.206 0.200
26	Body	0.130Inches $\pm$ 0.010	0.140 0.120
27	Body	45.0Angle $\pm$ 0.5	45.5 44.5
28	Body	1.5Angle $\pm$ 0.0	1.5 1.5
29	Body	0.660Inches $\pm$ 0.005	0.665 0.655
30	Body	0.660Inches $\pm$ 0.005	0.665 0.655
31	Body	0.700Inches $\pm$ 0.005	0.705 0.695
32	Body	5.500Inches $\pm$ 0.005	5.505 5.495
33	Body	6.8Angle $\pm$ 0.5	7.3 6.3

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order:	
Description: Body		Part Number:	646.9713
Inspection Dwg: 646.9700 Rev: D2		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.487	+/-0.005	0.487	✓			
4.784	+/-0.002	4.784	✓			
3.603	+/-0.002	3.603	✓			
2.422	+/-0.002	2.422	✓			
1.400	+/-0.002	1.400	✓			
0.375	+/-0.002	0.375	✓			
0.409	+/-0.002	0.409	✓			
0.350	+0.005/-0.000	0.351	✓			
0.875	+/-0.005	0.878	✓			
1.067	+/-0.002	1.067	✓			
2.608	+/-0.002	2.608	✓			
2.750	+/-0.002	2.750	✓			
2.892	+/-0.002	2.892	✓			
3.348	+/-0.002	3.348	✓			
3.597	+/-0.002	3.597	✓			
3.847	+/-0.002	3.847	✓			
0.544	+/-0.002	0.544	✓			
2.195	+/-0.002	2.195	✓			
3.395	+/-0.002	3.395	✓			
3.495	+/-0.002	3.495	✓			
4.595	+/-0.002	4.595	✓			
4.687	+/-0.002	4.687	✓			
4.734	+/-0.002	4.734	✓			
Ø0.177	+0.005/-0.001	0.177	✓			
Ø0.201	+0.005/-0.001	0.201	✓			
0.13 x 45°	+/-0.010 x +/-0.5°	0.128x45	✓			
1.500	+/-0.005	1.500	✓			
0.660	+/-0.005	0.660	✓			
0.660	+/-0.005	0.660	✓			
0.700	+/-0.005	0.700	✓			
5.500	+/-0.005	5.500	✓			
6.8°	+/-0.5°	6.8°	✓			

Measured by:	1 Kt	Checked by:	QC Inspector:
Date:	9-89 2010-10-02	Date:	18/10/12

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	16.04.05	New Issue	KJ	
B	16.11.24	Dimensions revised	KJ	



Container No: S116376



Part: 646.9713

Job No: 181424

Serial No/Batch: S116376

Revision: E

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/06/10

3AO
28-4



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041337**

Supplier: ATG001-VC
A.T.G. Industries Inc.
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

PO No: PO041337
PO Date: 10/12/18
Due Date: 11/9/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Belanger, NatashaPhone:

Attention: Lalande, Marc-Andre

Via: Ground

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	181931-A	644.4117	Bracket, Fwd Pivot 1-ISSUE P/O TO ATG: 2-Anodize Black -MPP-172 Section 2.1 -Hard Anodize IAW Mil- A-8625 Type 3 Class 2 3-Certification of Conformity is required 1-ISSUE P/O TO ATG: 2-Anodize Black -MPP-172 Section 2.1 -Hard Anodize IAW Mil- A-8625 Type 3 Class 2 3-Certification of Conformity is required	Firmed	-	11/9/18	1 pcs	0 pcs	1 pcs	\$8.10/pcs	\$8.10
3	181424	646.9713	Body Issue P/O to ATG : Anodize, Color Black, Prime as per Dwg 646.9700	Firmed	-	11/9/18	40 pcs	0 pcs	40 pcs	\$15.55/pcs	\$622.00



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PURCHASE ORDER **PO041337**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	181396	647.7811	Bracket B Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed	-	11/9/18	50 pcs	0 pcs	50 pcs	\$15.55/pcs	\$777.50
						NOV 07 2018					
5	179152	646.3110	Channel Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3100	Firmed	-	11/9/18	11 pcs	0 pcs	11 pcs	\$11.70/pcs	\$128.70
						OCT 31 2018					
6	183653	RBE350A93-3302-02-1	Handle Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3302-02-1 Rev. 11 -Certificate of Conformity is required.	Firmed	-	11/9/18	16 pcs	0 pcs	16 pcs	\$8.55/pcs	\$136.80
						OCT 31 2018					
7	176390	RBT18649-9-1	Top Plate Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	11/9/18	8 pcs	0 pcs	8 pcs	\$6.30/pcs	\$50.40
						NOV 05 2018					

Grand Total: \$1,723.50



Dart Aerospace Ltd.
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Canada

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PURCHASE ORDER
PO041337

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/24/18 2:36 PM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916496

Date: 15-Nov-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 40 ea	Part: 646.9713 ✓ Body Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23936	Rev: D	PO: PO041337 ✓ Line: 3
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>15/11/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

